

Work Order ID 62947

Thursday, October 14, 2010 12:34:10 PM

Page 1

Item ID: D3282-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Float.Web (206L/407)

Start Date: 10/14/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan:

Date: 10-10-14 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3282	Rev C

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut to length as per Dwg D3282.
per QSI0018☐ 2- inspect for surface damage as

DP

10-10-18

⑥

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA579 & Dwg D3282 2-Deburr

G.A 10/10/26

6

Ø

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

G.A 10/10/26

6

Ø

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		SL 10/10/27		6			
140  HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00		SAD 10-10-200		6			
150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		DD 10-10-28				28	

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Customer:




Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Skidtubes	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web □ A/RN/ALPS-3 <u>m104929</u>								
170  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
180  Packaging	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
Packaging	Memo	0.00							

SAD
10-10-28

6

10/10/28

16

10/10/28

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Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29

H10-10-28
6

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, October 14, 2010 12:34:14 PM

Page 1

Work Order ID: 62947

Parent Item: D3282-041

Parent Item Name: Float Web (206L/407)

Start Date: 10/14/2010


Required Date: 10/22/2010

Start Qty: 6.00

Required Qty: 6.00


Comments: IPP Rev:B 05.09.23 Procedure change KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20470AD4-7		Purchased	No			100	Each	1,064.000	57	342			
													
Rivet, Universal Head													


Location	Loc Qty	Loc Code
ST320	1064	
112492	1064	

SAD 10-10-28

D2792-130		Manufactured	No			160	Each	62.0000	1	6			
													
EXTRUSION													

Location	Loc Qty	Loc Code
MAT06	62	
42366	2	
61630	60	

② ④ DP 10-10-18

D3283-1		Manufactured	No			160	Each	29.0000	2	12			
													
Doubler													

SAD 10-10-28

Location	Loc Qty	Loc Code
ST046	25	
60203	25	
ST048	4	
57725	4	

⑩ ②

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DART AEROSPACE LTD		Work Order:	62947
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.600	✓		TAPE	GA-12
1.500	+/-0.010	1.500	✓		Vern	GA-01
3.000	+/-0.010	3.000	✓		"	"
6.000	+/-0.010	6.000	✓		"	"
1.250	+/-0.010	1.250	✓		"	"
30.000	+/-0.010	30.000	✓		TAPE	GA-12
1.500	+/-0.010	1.500	✓		Vern	GA-01
72.01	+/-0.030	72.01	✓		TAPE	GA-12
61.75	+/-0.030	61.75	✓		"	"
57.50	+/-0.030	57.50	✓		"	"
49.19	+/-0.030	49.19	✓		"	"
43.94	+/-0.030	43.94	✓		"	"
39.69	+/-0.030	39.69	✓		"	"
26.68	+/-0.030	26.68	✓		"	"
0.55	+/-0.030	0.551	✓		Vern	GA-01
1.970	+/-0.010	1.961	✓		"	"
2.38	+/-0.030	2.377	✓		"	"
0.05	+/-0.030	0.045	✓		Depth gage	GA-08
Ø 0.500	+0.006/-0.001	Ø 0.501	✓		Vern	GA-01
Ø 0.128	+0.005/-0.001	Ø 0.130	✓		"	"

Measured by: A.A	Audited by: JL	Prototype Approval:	N/A
Date: 10/10/26	Date: 10/10/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

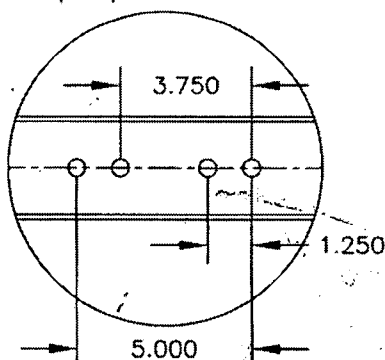
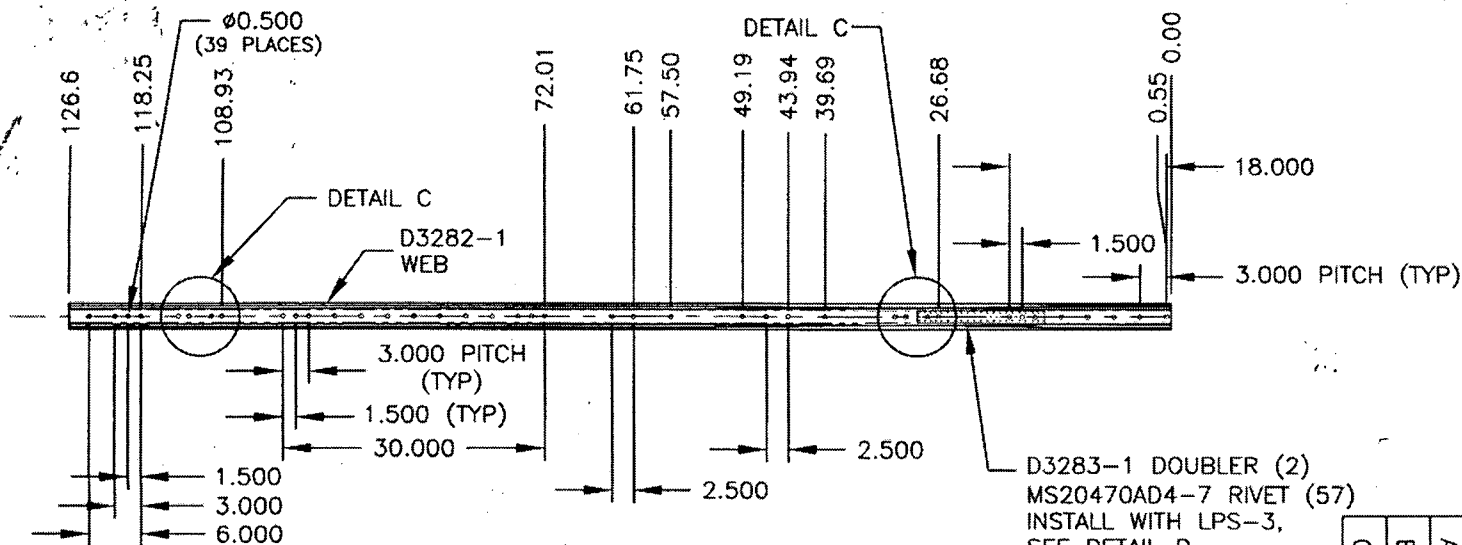
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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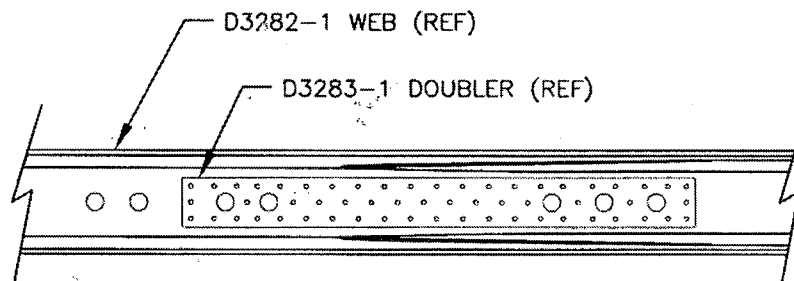
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CP	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
DATE	DATE	D3282
05.08.09	04.05.05	TITLE
	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS
	05.08.09	REMOVE D3390-1, NOW MACHINED
		NEW ISSUE
		SCALE
		1:20



DETAIL C
 SCALE 1:5
 RIVET HOLES NOT SHOWN
 FOR CLARITY



DETAIL D
 SCALE 1:5

D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WORK ORDER NO. 42947
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

SHOP COPY
 RELEASED
 UNCONTROLLED COPY
 SUBJECT TO A CHANGE
 NO. 42947

RELEASED
 05.09.12

PS 10-10-14

W/O:		WORK ORDER CHANGES					
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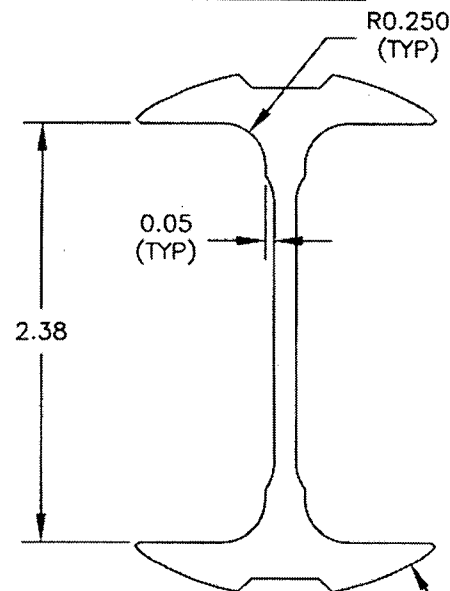
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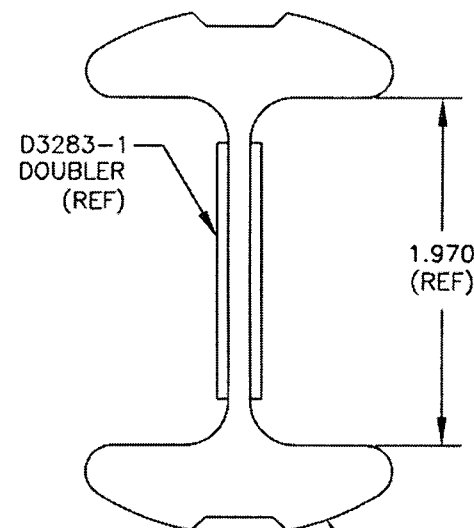
DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	TITLE	D3282	REV. C
				SHEET 2 OF 2
				SCALE
				1:20

SECTION A-A



SECTION B-B



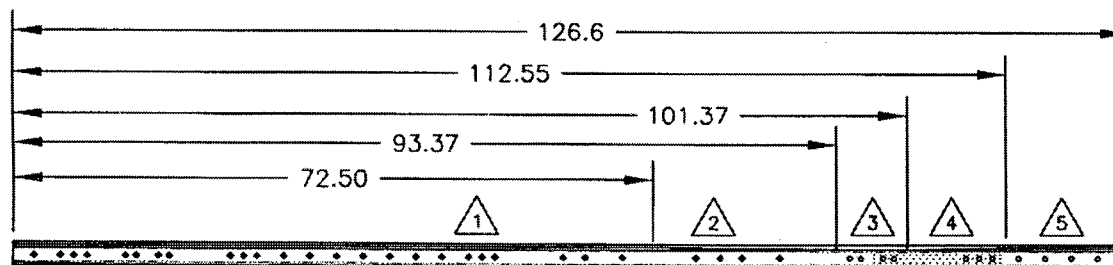
D2792-130
EXTRUSION
(REF)

D2792-130
EXTRUSION
(REF)

W/O 42947

D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 5 DRILL #30 ($\phi 0.128$ REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 6 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
05-04-12

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